

Work Order ID 67947

Tuesday, April 05, 2011 7:38:15 AM

Page 1

Item ID: D350-600-242

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacepod, RH, AS350/355

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/04/05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

Sub 11/04/05

CL 11-8-31

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

11-08-29

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 08 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo 1-Cut D2986 Neoprene Foam per template D2986T1 2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact adhesive A/R Batch: _____	0.00							
140 Small Fab	Small Fab	0.00							
Small Fab	Memo ****This step seperates hardware, previous steps is for body & floor****	0.00							

N/A already installed
as per B# 59241

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight. Install insert.

A/R Hysol batch: 117700 expire date: 12-05-13

A/R Milled fibres batch: 100859

2- Prime (grey) as necessary per OSI005

Primer batch: 116563

Hardner batch: 116563

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: _____

N/A already installed as per B# 59241

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-05-29

11-05-30

11-08-30 (1)

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Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Wing Walk as per dwg QSI005 4.4 Batch 117863 0.00



HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

FT 11-08-30

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11-8-30

200

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/31 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Required Qty: 1.00

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
				ST327	57		_____
				110179	4		_____
				115518	3		_____
				<u>116556</u>	50		<u>xy</u> _____
AN960JD516	NAS1149D0563J	Purchased	No	140	Each	0.0000	1 1
				118206			<u>25 11-08-29</u>
Washer							
AN960JD8	NAS1149DN832J	Purchased	No	140	Each	0.0000	20 20
				117316			<u>25 11-08-29</u>
Washer							

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Picklist Print

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Work Order ID: 67947

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2179 Manufactured No 140 Each 37.0000 2 2



Doubler



RT 11-08-29

Location Loc Qty Loc Code

ST007 37

35432 37

D2237 Manufactured No 140 Each 69.0000 2 2



Striker Plate



X2

RT 11-08-29

70558

Location Loc Qty Loc Code

ST009 69

64426 1

64762 4

66139 64

D2986 Manufactured No 140 Each 0.0000 5.62 5.915789



Black Neoprene Foam .125

NA already installed as per B#59241



D3538-1 Manufactured No 140 Each 20.0000 2 2



Hinge Bracket



RT 11-08-29

68505

Location Loc Qty Loc Code

ST066 20

66018 20

D3554-7 Manufactured No 140 Each 12.0000 1 1



Ball Stud



RT 11-08-29

69496

Location Loc Qty Loc Code

ST067 12

37674 2

65123 10

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Shop Packet Print

Page 2

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Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3567-2 Manufactured No

140 Each 21.0000 1 1



Decal



85 11-08-29

Location

Loc Qty

Loc Code

ST067

21

39678

2

50375

19

x1

MS20426AD4-5 Purchased No

140 Each 5,949.000 4 4



Rivet

85 11-08-29

Location

Loc Qty

Loc Code

MEZZ

535

6733

535

ST317

5414

6874

5414

x4

ALS4-1032-130 Purchased No

150 Each 0.0000 28 28



Insert

118237

85 11-08-29

AN526C832R10 Purchased No

150 Each 107.0000 10 10



Screw

85 11-08-29

Location

Loc Qty

Loc Code

ST327

107

113154

10

115101

97

x10

AN526C832R14 Purchased No

150 Each 536.0000 2 2



Screw

104916

85 11-08-29

Location

Loc Qty

Loc Code

ST327

536

104916

536

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Parent Item Name: Spacepod, RH, AS350/355

Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

150

Each

0.0000

2

2



Washer

D2228

Manufactured

No

150

Each

33.0000

4

4



Bracket Plate

118077



25 11-08-29

Location

Loc Qty

Loc Code

ST009

33

64427

33

D2464

Manufactured

No

150

f

397.7800

10.8

11.36842



3/4 Seal



25 11-08-29

Location

Loc Qty

Loc Code

ST404

397.78

61878

397.78

D2585

Manufactured

No

150

Each

43.0000

2

2



Mounting Channel



25 11-08-29

Location

Loc Qty

Loc Code

ST017

43

64761

1

66142

42

D2586

Manufactured

No

150

Each

112.0000

2

2



Door Latch



25 11-08-29

Location

Loc Qty

Loc Code

ST204

112

64656

12

64774

100

82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2621

Manufactured No

150

Each

44.0000

2

2



Latch Plate, 350 Spacepod

Location

Loc Qty

Loc Code

ST019

44

56526

44

150

Each

22.0000

1

1

D2857-1

Manufactured No



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

22

64435

2

65090

20

150

Each

22.0000

1

1

D2857-2

Manufactured No



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

22

64463

12

65091

10

150

Each

7.0000

1

1

D3557-1

Manufactured No



Bracket

Location

Loc Qty

Loc Code

ST067

7

64452

7

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Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

150

Each

228.0000

18

18



Nut

118242



BT 11-08-29

Location

Loc Qty

Loc Code

ST300

228

117087

228

MS21042L3

Purchased

No

150

Each

2,062.000

2

2



Nut

117441



BT 11-08-29

Location

Loc Qty

Loc Code

ST300

2062

116391

462

116540

800

116549

800

MS27039-08-11

Purchased

No

150

Each

37.0000

2

2



Screw



BT 11-08-29

Location

Loc Qty

Loc Code

ST290

37

116289

37

x2

MS27039-1-15

Purchased

No

150

Each

102.0000

2

2



Screw



BT 11-08-29

Location

Loc Qty

Loc Code

ST292

102

116169

2

116916

100

x2

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Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased

No

150

Each

103.0000

2

2



Washer

117460



BT 11-08-29

Location

Loc Qty

Loc Code

ST277

103

115935

3

116373

100

D350-600-449

Manufactured

No

200

Each

3.0000

1

1



Switch Relocation

CHC7001



Location

Loc Qty

Loc Code

FG120

3

66736

3

200

Each

1.0000

1

1

K10021

Manufactured

No



Spacepod Hardware Kit (-241)



B73207

Location

Loc Qty

Loc Code

ST122

1

67087

1

110

Each

0.0000

1

1

D3186-4

Manufactured

No



Spacepod Door, RH

D3187-2

Manufactured

No

110

Each

4.0000

1

1



Spacepod Floor



BT 11-08-29

Location

Loc Qty

Loc Code

ST241A

4

59241

3

59579

1

XC

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Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

A3235-020-935

Purchased

No

110

Each

383.0000

8

8



85 11-08-24

Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

383

106150

383

x 8

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